

Work Order ID 80921

80921

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March-05-12 10:48:29 AM

Item ID: D3578-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 05/03/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 19/03/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/05 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3578	Rev A

100 0.00

100

Waterjet FLOW WATER JET Memo 0.00

FLOW CNC Waterjet 1-Cut as per Dwg D3578 (Run prog. D3578-1)
 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

M 12 03 10 50

110 0.00

110

QC QC2- Inspect parts off machine FAI/FAIB Memo 0.00

Quality Control

M 12 03 12 50

120 0.00

120

QC QC8- Inspect parts - second check Memo 0.00

Quality Control

counts
XYD

8.210312

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop ***NS2***

50

50

Reference:

Run Start *NR1*

Stop ***NR2***

Date:

**Insp.
Stamp**

130

0.00

Memo

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

Memo

Quality Control

0.00

150

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

Hand Finishing

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170		0.00							
170	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per dwg D3578								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

50x 4 HU 2/03/13

5/2/03/15 (50)

(XP)

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <i>S245A</i>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

50x.80 12-03-16

12/3/16

12-03-16

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

March-05-12 10:48:34 AM

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Work Order ID: 80921

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Parent Item: D3578-041

D3578-041

Parent Item Name: Doubler

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: A07.04.11New issueEC
IPP RevB 10.10.21 remove D3569-1 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3 *MS20426AD3-3* Rivet		Purchased	No			110	Each	2,593.000	2	100			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		2593							
				119109		2154							
				19099		439							
M6061T6S.080 *M6061T6S 080* 6061-T6 .080 Sheet		Purchased	No			170	sf	231.2000	0.007	0.368421			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		231.2							
				117285		4.8							
				119766		109.5							
				120349		116.9							
MS21075L3 *MS21075L 3* Nutplate		Purchased	No			170	Each	317.0000	1	50			
**													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST303		317							
				120459		177							
				120910		140							

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

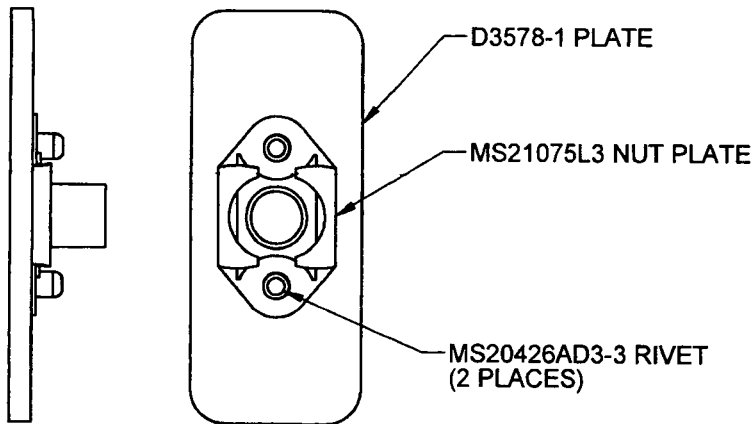
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12		TITLE DOUBLER	SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	



RELEASED
07.04.02 #8

D3578-041 PARTS LIST:

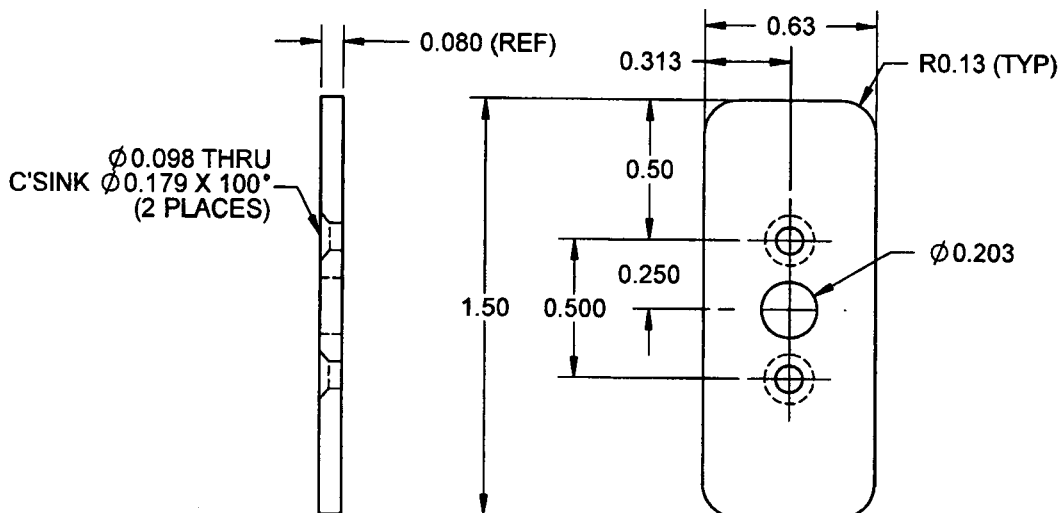
QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER

D3578-041 NOTES:

- 1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *8092140*
12/03/05



D3578-1 PLATE

D3578-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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Dart Aerospace Ltd

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